

What is claimed is:

1. A laser welding method for welding plural bodies to be welded comprising the steps of:
blowing an inert gas on a part to be welded from a coaxial nozzle,
blowing a compressed shielding gas around the part to be welded so as to cover the inert gas from at least one discharging nozzle provided at the outer side of the coaxial nozzle, and
irradiating a converged laser onto the part to be welded, and thus, melting the part under the shielded condition from an outside air to weld the plural bodies.
2. A laser welding method as defined in claim 1, wherein the inert gas and the shielding gas are discharged in constant flow.
3. A laser welding method as defined in claim 1 or 2, wherein the inert gas is blown in columnar shape, and the shielding gas is blown cylindrically.
4. A laser welding method as defined in claim 1 or 2, wherein the gauge pressure p_1 of the inert gas and the gauge pressures p_2 and p_3 of the inner and the outer discharging nozzles satisfy the relation of $p_1 > p_2 \geq p_3$.
5. A laser welding method as defined in claim 1 or 2, further comprising the step of evacuating gases around the melting part by an evacuating nozzle.
6. A laser welding apparatus for welding plural bodies to be welded comprising:
a coaxial nozzle to blow an inert gas on a part to be welded,
at least one discharging nozzle, provided at the outer side of the coaxial nozzle, to blow a compressed shielding gas around the part to be welded so as to cover the inert gas,

a laser oscillator to oscillate a laser, and
a condenser to converge the laser, and thus, melt the part to be welded through the irradiation of the converged laser under the shielded condition from an outside air to weld the plural bodies.

7. A laser welding apparatus as defined in claim 6, wherein the at least one discharging nozzle is provided coaxially for the coaxial nozzle.

8. A laser welding apparatus as defined in claim 6 or 7, further comprising an evacuating nozzle to evacuate gases around the melting parts.

9. A laser welding apparatus as defined in claim 8, wherein the evacuating nozzle is provided coaxially for the coaxial nozzle and the at least one discharging nozzle.

10. A laser welding apparatus as defined in claim 8 or 9, wherein the evacuating nozzle is provided between the inner and the outer coaxial discharging nozzles.

11. A laser welding apparatus as defined in claim 6, 7 or 9, wherein the discharging holes of the at least one discharging nozzle and the evacuating nozzle have cylindrical shapes.